

Work Order ID 50391

July 13, 2009 12:54:44 PM

Page 1

Item ID: D3159-041

Accept

Setup Start

Revision ID: C

Stop

Item Name: Bracket Assembly

Start Date: 7/15/09 Start Qty: 8.00

Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 8.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3159

Rev C

100

0.00



SHEAR

Shear

Memo

0.00

Shear

Blank size: 1.700" x 1.545" x .063" thick. Grain along 1.545"

IB

9-8-11

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per Folio FA237LJ Stack of 7

IB

9-8-11

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

IB 9-8-11

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Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

2) 8/08/12

counter

QC

Memo

0.00

Quality Control

140

Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

1-Deburr break all sharp edges .005 to 0.010 12-C'sink holes as per Dwg D3159

150

NC BRAKE

0.00

Brake NC

Memo

0.00

Brake NC

Form as per drawing

Deburr M-k 08/08/11
e'sink hole M-k 08/08/13 (44X) (44X)

EB 09/08/13

QC 08.08.13

QC5

=>

8/08/13

counter
(44X)

f

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Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 HandFinish	Chemical Conversion Coat per QS1005 4.1	0.00							
Hand Finishing	Memo	0.00							
	QC3								
170 Small Fab	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Assemble as per dwg.								
	QC5- Inspect part completeness to step on W/O	0.00							
180 QC	QC	0.00							
Quality Control	Memo	0.00							

41 04-08-13

44

>

8/09/08/13

44

=> 5 or less

count

44

φ

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Revision ID: C

Stop

Item Name: Bracket Assembly

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Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 8.00

Customer:

Reference:

Run Start

Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Stop

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Identify as per dwg & Stock Location

0.00



Packaging

Memo

0.00

Packaging

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

9/8/17

44x SP

09/08/25

MF 09-08-24

Picklist Print

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Page 1

Work Order ID: 50391

Parent Item: D3159-041RevC

Parent Item Name: Bracket Assembly

Comments:

Start Date: 7/15/09

Required Date: 7/15/09

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No			170	sf	135.5726	0.1566	44		
6061-T6 .063 Sheet												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

135.5726316

109463

1

110551

134.572632

100

Each

8,433.000

16.0000

109463

B 9-8-11

MS20426AD3-13

Purchased

No

RIVET

M7681

442

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

8433

104374

4433

110398

4000

170

Each

8.0000

8.0000

MS21059L06

Purchased

No

Nutplate

*

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

8

13131

8

M112255

882

09/08/13 44

09/08/13 44

DART AEROSPACE LTD	Work Order:	50391
Description: BRACKET ASSEMBLY	Part Number:	D3159-041
Inspection Dwg: D3159-1 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article** ☐ **Prototype**

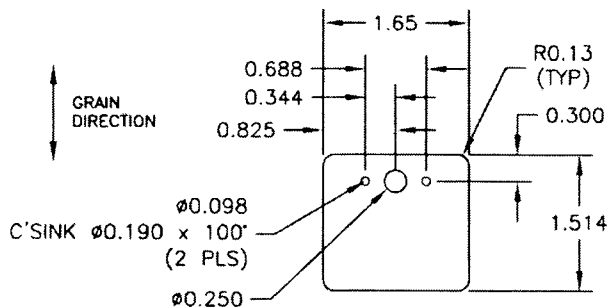
[illegible]

Measured by: HB	Audited by: S	Prototype Approval: A
Date: 9-8-11	Date: 09/08/12	Date: A

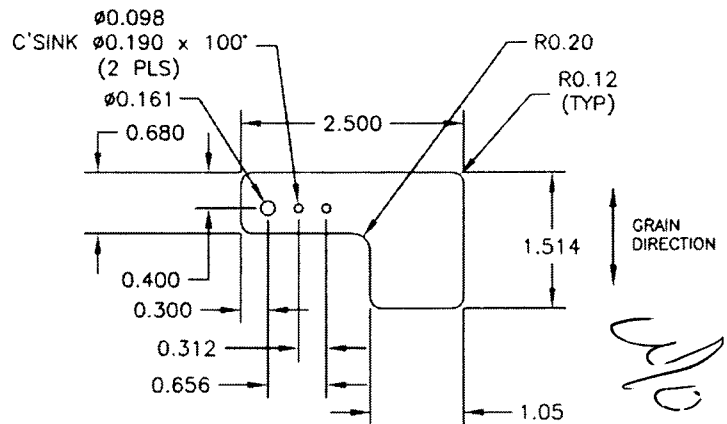
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART

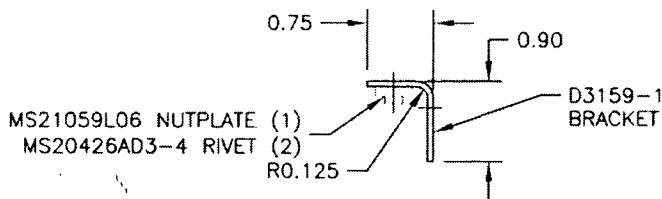
DESIGN DS	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3159	REV. C SHEET 1 OF 1
DATE 05.11.21		TITLE BRACKET ASSEMBLY	SCALE 1:2
A	02.04.30	NEW ISSUE	
B	04.10.18	ADD PART MARKING	
C	05.11.21	CORRECT VIEW	



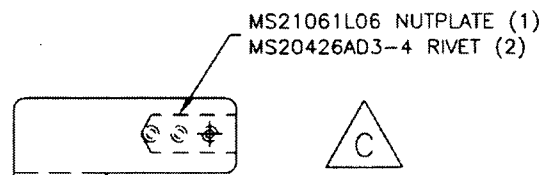
D3159-1F FLAT PATTERN
(USED TO MAKE D3159-1 BRACKET)



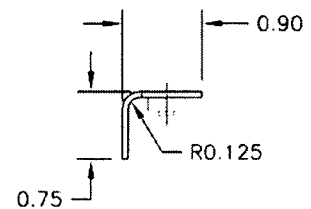
D3159-3F FLAT PATTERN
(USED TO MAKE D3159-3/-4 BRACKETS)



D3159-041 BRACKET ASSEMBLY



D3159-3/-4
BRACKET



D3159-043 BRACKET ASSEMBLY (SHOWN).
REPLACES PREMIER P/N B30-23000-259
(D3159-044 BRACKET ASSEMBLY (OPPOSITE).
REPLACES PREMIER P/N B30-23000-260)

NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK EDGES 0.005 TO 0.010
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY D3159-041/-043/-044 WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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